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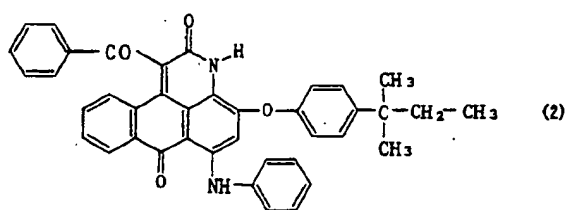
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(54) **WATER-BASED MAGENTA INK COMPOSITION AND METHOD OF INK-JET RECORDING**

(57) The present invention relates to a water-based magenta ink composition which has satisfactory storage stability, has a hue and vividness suitable for ink-jet recording, and gives prints having high fastness to light and water, and magenta dye suitable therefore.

More particularly, the present invention relates to a water-based magenta ink composition characterized by containing disulfonic acid derivative of a compound represented by Formula(2)

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or the salt thereof as the dye component,  
 an ink-jet recording method using said composition, and  
 magenta dye containing little inorganic salt and little  
 mono-sulfonic acid compound and being suitable for the  
 said composition.

## D scription

### TECHNICAL FIELD

5       **[0001]**       The present invention relates to an ink composition, more particularly to a water-soluble magenta ink composition for ink-jet recording, which contains an anthrapyridone disulfonic acid compound or the salt thereof as the colorant having a wide range of blend color and an excellent property in color tone, light fastness and water fastness; an ink-jet recording method using said composition; an water-based magenta dye comprising said disulfonic acid compound or the salt thereof having a low content of inorganic salt; and a method for producing said disulfonic acid compound or the salt thereof having a low content of said inorganic salt.

### 10       BACKGROUND ART

15       **[0002]**       Diverse ink jetting processes have been developed for the recording method by ink-jet printer, and each method comprises the process of generating ink droplets and then depositing them onto various recording materials (such as paper, film, cloth). The recording method by means of ink-jet printer has rapidly been spread in recent years and will be propagated in future because the method makes no noise due to the system in which a recording head does not contact with the recording material and because the method advantageously allows the printer easily to be downsized, to work in a high-speed and to give color printing. In order to record in color an image information or a character information on a computer color display by an ink-jet printer, it is generally printed to by subtractive color mixing of four colored-inks, namely yellow, magenta, cyan and black. In order to reproduce an image pictured by additive color mixing of R, G, B on a CRT display as identical as possible by subtractive color mixing, the dyes used therefor, especially for a YMC ink, are desired to have color hues close to the respective standards of YMC("Japan Color Standard Paper" published by Japan Printing Machinery Manufacturers Association)and vividness. Additionally, it is required that the resulting ink composition is stable for long-term storage and that the resulting printed image is of a high optical density and has excellent fastness including water fastness and light fastness. The present invention relates to a magenta ink.

25       **[0003]**       The use of ink-jet printers are enlarged from a small-sized one for OA to a big-sized one for industrial use. So, there arise a keen demand more than ever on fastness such as water fastness and light fastness of the printed image. The water fastness is substantially improved by coating inorganic or organic micro particles such as cationic polymer(not an inorganic particle), porous silica, alumina sol and special ceramics which can absorb dye from ink with PVA resin on a paper sheet. Various coated sheets for ink-jet printing are already available on the market, but they can not always give a satisfactory water fastness. Light fastness is not yet improved by an established technique. Especially, the majority of magenta dyes, one of four original colors of YMCK, are poor in light fastness, and its improvement is an important problem to be solved.

30       **[0004]**       The chemical skeletal structure of magenta dyes used in a water-soluble ink for ink-jet recording is represented by a xanthene type disclosed by JP Laid-Open No.89811/1979, JP Laid-Open No.60053/1996 and JP Laid-Open No.143798/1996, or an azo type using the H acid disclosed by JP Laid-Open No.62562/1986, JP Laid-Open No.156168/1987, JP Laid-Open No.203970/1991, JP Laid-Open No.157698/1995 and JP Publication No.78190/1995. The xanthene type is indeed excellent in hue and vividness, but is inferior in light fastness. The azo type using the H acid is good in hue and water fastness, but is inferior in light fastness and vividness. As disclosed by JP Laid-Open No.203970/1991, for example, some magenta dyes excellent in vividness and light fastness have been developed from the azo type family, but are still inferior in light fastness to the other hue of dyes such as yellow dyes and cyan dyes represented by copper phthalocyanine type.

35       **[0005]**       For a chemical skeletal structure of magenta dyes excellent in vividness and light fastness, an anthrapyridone type is known as disclosed by JP Laid-Open No.195775/1982, JP Laid-Open No.74173/1984 and JP Laid-Open No.16171/1990, but is not yet able to satisfy all of the properties in a wide range of blend color, hue, vividness, light fastness, water fastness and stability in solution. The USP 2,644,821 describes an anthrapyridone type compound including the compound of below Formula (2) and its disulfonic acid compound as a good light fastness and water fastness of dye, but they are intended to use mainly for fiber-dyeing and can not show a high quality suitable for an ink-jetting ink, if used directly with no additional procedures.

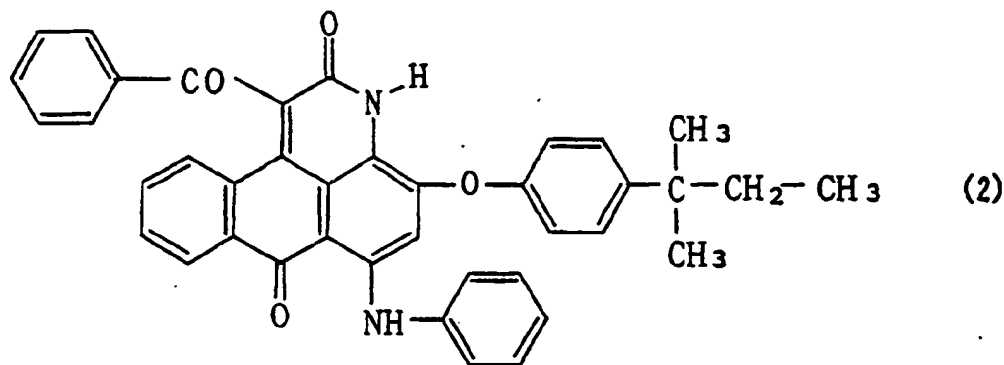
40       **[0006]**       An object of the present invention is to provide a water-based magenta ink composition which has a wide range of blend color in hue and vividness suitable for ink-jet recording and gives the recorded material a high fastness in light fastness and water fastness; and a magenta dye suitable therefor.

### DISCLOSURE OF THE INVENTION

55       **[0007]**       The present inventors made a diligent study to solve the above problem and, as a result, have completed the

present invention. Namely, the present invention is as follows:

(1) A water-based magenta ink composition, which comprises the disulfonic acid derivative of a compound represented by Formula(2) or the salt thereof as the dye component.

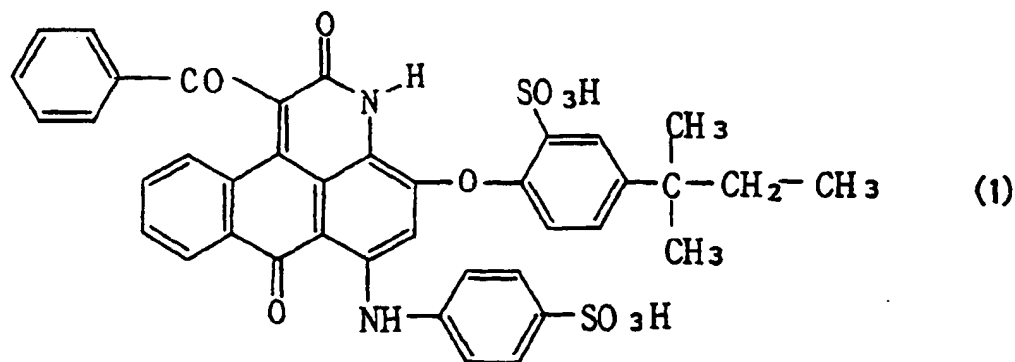


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(2) A water-based magenta ink composition according to the above term (1), wherein said disulfonic acid derivative of a compound represented by Formula(2) is 85% or more (area ratio according to high performance liquid chromatography(HPLC)) in content and a monosulfonic acid compound of the compound represented by Formula(2) according to the above terms (1) is 10% or less(area ratio according to HPLC)in content.

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(3) A water-based magenta ink composition according to the above term (1) or (2), wherein said disulfonic acid compound is a compound (or the salt thereof, hereinafter likewise) represented by Formula(1).



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(4) A water-based magenta ink composition according to any of the above terms (1) to (3), wherein said composition contains water and an organic solvent.

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(5) A water-based magenta ink composition according to any of the above terms (1) to (4), wherein an inorganic salt in said dye component is 1% or less in content.

(6) A water-based magenta ink composition according to any of the above terms (1) to (5), wherein said composition is for ink-jet recording.

(7) A method for ink-jet recording, which comprises using the water-based magenta ink composition according to any of the above terms (1) to (5) for an ink in the ink-jet recording way that ink droplets are jetted responding to recording signals to record on a recording material.

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(8) A method for ink-jet recording, which comprises using the water-based magenta ink composition according to any of the above terms (1) to (5) for a magenta ink, and using a water-based cyan ink containing a water-soluble metal phthalocyanine dye for a cyan ink in the ink-jet recording way that ink droplets are jetted responding to

recording signals to record on a recording material.

(9) A method for ink-jet recording according to the term (8), wherein said recording material is a polyamide fiber material, which is thermally treated after jetting said ink composition.

(10) A method for ink-jet recording according to the term (8), wherein said recording material is a sheet for information transmitting.

(11) A method for ink-jet recording according to the term (10), wherein said sheet for information transmitting is a surface-treated sheet.

(12) An ink-jet printer, which comprises being equipped with a container storing the water-based magenta ink composition according to any of the above terms (1) to (5) and a container storing the water-based cyan ink containing a water-soluble metal phthalocyanine dye.

(13) A dye for water-based magenta ink, which comprises containing the disulfonic acid compound represented by Formula(1) or the salt thereof by 90% or more(area ratio according to HPLC), the monosulfonated product (monosulfonic acid compound) of the compound represented by Formula(2) by 5% or less(area ratio according to HPLC), and the inorganic salt by 1% or less.

(14) A method for producing the disulfonic acid compound represented by Formula (1) or the salt thereof, which comprises disulfonating the anthrapyridone compound represented by Formula (2) with fuming sulfuric acid, salting out conventionally the disulfonic acid compound thus obtained to give a wet cake, and then treating the wet cake with a hydrous lower alcohol.

## BRIEF DESCRIPTION OF THE DRAWINGS

### [0008]

Fig.1 is a diagram showing the range of blend color of the dyes.

### Description of Symbols

[0009] In Fig.1, the axis X represents  $a^*$ , and the axis Y represents  $b^*$  on the  $L^* a^* b^*$  colorimetric system. Y shows yellow, R shows red, M shows magenta, B shows blue, C shows cyan and G shows green. The solid line expresses the range of blend color of the dyed product in Example 2 and the dotted line expresses the range of blend color of the dyed product in Comparative Example 1.

## BEST MODE FOR CARRYING OUT THE INVENTION

[0010] The water-based magenta ink composition of the present invention is characterized by containing the disulfonic acid compound of the compound represented by the above Formula(2) or the salt thereof. The disulfonic acid compound of the compound represented by the above Formula(2) is 85% or more, preferably 90% or more, more preferably 92% or more, and specially preferably 95% or more in content in the dye component by area ratio according to HPLC( hereinafter measured in the condition as described below: Column: Inertsil ODS-2(6.0, I,D, 150mm), Mobile Phase:  $\text{CH}_3\text{CN}/0.05\text{wt}\%\text{NH}_4\text{H}_2\text{PO}_4=40/60(\text{w/w})$ , Flow Rate: 0.8ml/min, Col. Temp. :40°C , Detector: UV-254nm). An example of the disulfonic acid derivative of the compound represented by the above Formula(2) is represented by the above Formula (1).

[0011] The dye component used in the present invention, which is obtained by sulfonating the compound represented by the above Formula(2), contains the monosulfonic acid compound by-produced in the production process in addition to the disulfonic acid. The content of the monosulfonic acid compound is desirably as low as possible for the purpose of easy ink production ( for example, filtration), ink storage stability and vividness of the recorded product, and is 10% or less(including 0%), preferably 5% or less, more preferably 2% or less and specially preferably 1% or less. It is of course best that the ink composition of the present invention contains no compound of Formula (2).

[0012] The dye component used in the present invention can be obtained by sulfonating the compound represented by Formula (2)(the compound of Formula (2) is described in USP 2,644,821 ) in sulfuric acid containing fuming sulfuric acid. The concentration of fuming sulfuric acid in sulfuric acid is preferably 5 to 12 % by weight, more preferably 6 to

10 % by weight. The reaction temperature is generally 0 to 60 °C, preferably 10 to 30°C. Further, the reaction time varies depending on the reaction temperature, but is generally 5 minutes to 20 hours, and about 30 minutes to 5 hours in an preferable embodiment. The sulfonation terminates when no compound of the formula (2) is identified and the monosulfonic acid compound decreases in concentration to 10% or less, preferably 5% or less, more preferably 2% or less, especially preferably 1% or less in concentration according to the HPLC area ratio. After the completion of the reaction, the reaction solution is poured in an ice-water, followed by salting out, filtration and drying, to obtain the dye containing the compound of Formula (1)(hereinafter, representing the dye containing the monosulfonic acid compound and the disulfonic acid compound). The product is desired to be treated with a lower alcohol such as methanol and ethanol upon necessity to make a dye having a low content of inorganic salt suitable for the ink composition of the present invention. It is sufficient for the treatment to conduct a desalting treatment, for example, by a conventional method such as reverse osmotic membrane or by stirring a dry product or a wet cake, preferably a wet cake of the dye component of the present invention in hydrous lower alcohol, preferably in a mixed solvent of methanol and water, then filtering and drying. Either treatment is possible, however, the latter one is more preferable. The preferable amount of a solvent in the latter treatment is about 1 to 20 times(by weight), preferably 2 to 10 times that of the dry product or the wet cake. There is no limit in treatment time as it varies depending on a treatment amount, an amount of hydrous lower alcohol and the other condition, but it is generally several minutes to several hours, preferably about 10mins to 3hrs. There is no limit in treatment temperature, in particular, but is generally 10 to 40°C, preferably an ambient temperature. The alcohol content in a hydrous lower alcohol is generally 20% to 95% by weight, preferably 50% to 90% by weight, more preferably 70% to 85% by weight.

**[0013]** The dye thus obtained exists as a free acid or the salt thereof. The alkali metal salt, the alkali earth metal salt, the alkylamine salt, the alkanolamine salt or the ammonium salt may be used in the present invention. The preferable salt includes an alkali metal salt such as the sodium salt, the potassium salt and the lithium salt, and an alkanolamine salt such as the monoethanolamine salt, the diethanolamine salt, the triethanolamine salt, the monoisopropanolamine salt, the diisopropanolamine salt and the triisopropanolamine salt.

**[0014]** The dye component thus obtained contains the monosulfonic acid compound and the inorganic salt in their least amounts and, therefore, is suitable for an ink composition of the present invention. The content of monosulfonic acid compound, for example, can be decreased to 10% or less (including 0%), preferably 5% or less, more preferably 2% or less, specially preferably 1% or less relative to the total dye component according to the HPLC area ratio. The content of the inorganic salt can be decreased to 5% or less, preferably 3% or less, more preferably 1% or less relative to the total dye component. The content of the inorganic salt can be determined by measuring  $\text{Cl}^-$  and  $\text{SO}_4^{2-}$  according to ion chromatography; heavy metals according to atomic absorption spectrography or inductively coupled plasma emission spectrography; or  $\text{Ca}^{2+}$  and  $\text{Mg}^{2+}$  according to ion chromatography, atomic absorption spectrography or inductively coupled plasma emission spectrography.

**[0015]** The water-based ink composition of the present invention can be obtained by dissolving the above dye component in water or a hydrous solvent(a water containing organic solvent as will be described later). The preferable ink pH is about 6 to 11. The more preferable dye component of a water-based ink composition, when used in an ink-jet recording printer, contains an inorganic material such as the chloride and the sulfate of a metal positive ion in the amount as little as possible. For example, the total content of sodium chloride and sodium sulfate in the dye component is 1% by weight or less, preferably 0.5% or less, more preferably 0.1% or less.

**[0016]** The water-based ink composition of the present invention is prepared by using water as a medium and contains the dye component preferably by 0.1 to 20%, more preferably 1 to 10%, more preferably 2 to 8% by weight. The water-based ink composition of the present invention also may contain a water-soluble organic solvent 60% or less, preferably 50% or less, more preferably 40% or less, the most preferably 30% or less by weight. The lower limit may be 0% by weight, but is generally 5% or more, more preferably 10% or more, the most preferably 10 to 30% by weight. The water-based ink composition of the present invention may contain ink regulators by 0 to 10%, preferably 5% or less by weight. The remainder except the above components is water.

**[0017]** The water-soluble organic solvent includes a C1 - C4 alkanol such as methanol, ethanol, propanol, isopropanol, butanol, isobutanol, secondary butanol and tertiary butanol; a carboxylic amide such as N,N-dimethylformamide and N,N-dimethylacetoamide; a lactam such as  $\epsilon$ -caprolactam and N-methylpyrrolidin-2-one; urea; a cyclic urea such as 1,3-dimethylimidazolidin-2-one or 1,3-dimethylhexahydropyrimidin-2-one; a ketone or a keto-alcohol such as acetone, methyl ethyl ketone, and 2-methyl-2-hydroxypentan-4-one; an ether such as tetrahydrofuran and dioxane; mono-, oligo- or poly-alkylene glycol or thioglycol having C2 - C6 alkylene units, such as ethylene glycol, 1,2- or 1,3-propylene glycol, 1,2- or 1,4-butylene glycol, 1,6-hexylene glycol, diethylene glycol, triethylene glycol, dipropylene glycol, thiodiglycol, polyethylene glycol and polypropylene glycol; polyols (triols) such as glycerin and hexane-1,2,6-triol; C1 - C4 alkyl ethers of polyhydric alcohols, such as ethylene glycol monomethyl ether, ethylene glycol monoethyl ether, diethylene glycol monomethyl ether, diethylene glycol monoethyl ether, triethylene glycol monomethyl ether, and triethylene glycol monoethyl ether;  $\gamma$ -butyrolactone; and dimethylsulfoxide. These solvents may be used in a combination of two or more. Two or more of these are in many cases combined to use.



**[0018]** Among these water-soluble organic solvents, preferable examples are N-methylpyrrolidin-2-one and mono-, di- or tri-alkylene glycol having C2 - C6 alkylene units( mono-, di-or triethylene glycol, dipropylene glycol), glycerine, and dimethylsulfoxide. At least one or a combination of two or more selected from the above mentioned groups consisting of them is preferably used. At least one selected from the group consisting of N-methylpyrrolidin-2-one, glycerine, ethylene glycol, diethylene glycol and dimethylsulfoxide is especially preferably used.

**[0019]** The ink regulators, which are all the components except water, a dye component and a water-soluble organic solvent, include a preservative, a pH adjusting agent, a chelating agent, a rust preventive, a water-soluble ultraviolet absorbing agent, a water-soluble polymeric compound, a dye dissolving agent, and a surfactant. The preservative includes sodium dehydroacetate, sodium sorbate, sodium 2-pyridinethiol-1-oxide, sodium benzoate and sodium pentachlorophenol. The pH adjusting agent includes any substance that can control the ink pH within a range of 6 to 11 with no adverse effect on the ink preparation. The examples are alkanolamines such as diethanolamine and triethanolamine; alkali metal hydroxides such as lithium hydroxide, sodium hydroxide, and potassium hydroxide; ammonium hydroxide; or alkali metal carbonates such as lithium carbonate, sodium carbonate and potassium carbonate. The chelating reagent includes sodium ethylenediaminetetraacetate, sodium nitrilotriacetate, sodium hydroxyethylenediaminetriacetate, sodium diethylenetriaminepentaacetate, and sodium uramil diacetate. The rust preventive includes acidic hyposulfite salts, sodium thiosulfate, ammonium thioglycolate, diisopropylammonium nitrite, tetranitrate pentaerythritol, and dicyclohexylammonium nitrite.

**[0020]** The ink composition of the present invention is prepared by adding the above dye and the above water-soluble organic solvent and the ink regulators upon necessity to water such as distilled water with no impurities contained therein and mixing them together. Alternatively, the dye may be added to dissolve in a mixture of water, the above water-soluble organic solvent and the ink regulators. The resulting ink Composition may be filtered, if necessary, to remove the contaminants from the composition.

**[0021]** A recording material used in ink-jet recording includes an information transmittance sheet such as paper and film, fiber and leather.

**[0022]** It is preferable that the information transmittance sheet is surface-treated and, practically, is set with an ink-acceptable layer on the base material. The ink-acceptable layer can be set, for example, by impregnating or coating a cationic polymer on the above basement material; or by coating an inorganic fine-grain which can absorb the dye from an ink such as porous silica, alumina sol and special ceramic together with a hydrophilic polymer such as polyvinyl alcohol and polyvinyl pyrrolidone on the above base material. The sheet set with such an ink-acceptable layer is generally called an ink-jet special paper (film) or a glossy paper (film), and is available on the market, for example, as Pictorico(by Asahi Glass KK), Color BJ Paper, Color BJ Photofilm sheet(by Canon KK), Color Image Jet special paper(by Sharp KK), Superfine special glossy film(by Seiko Epson KK) and Pictafine (by Hitachi Maxell KK). A plain paper can be of course used for a recording material.

**[0023]** The preferable fiber is a polyamide fiber such as nylon, silk and wool, and is of nonwoven fabric or cloth. The fiber can be dyed by adhering an ink composition of the present invention to said fiber preferably by ink-jet recording, and then fixing by wet heating(for example, at about 80 to 120°C) or dry heating(for example, at about 150 to 180°C) to give the dyed product which is excellent in vividness, light fastness and washing fastness.

**[0024]** A method for ink-jet recording of the present invention can be carried out, for example, by setting an ink-jet printer with the container containing the above water-base magenta ink composition, and then recording conventionally on a recording material. The ink-jet printer includes a piezo type printer utilizing the mechanical vibration and a bubble-jet type printer using bubbles generated by heating.

**[0025]** In the method for ink-jet recording of the present invention, the above water-based magenta ink composition is used together with a yellow ink composition, a cyan ink composition, and a black ink composition upon necessity. The water-based cyan ink composition, if it contains a soluble metal phthalocyanine dye, is preferably used together with the above water-based magenta ink composition to give a good result that the color tone changes hardly in a light fastness test after color-mixing. Metals in the water-soluble metal phthalocyanine dye includes copper, nickel and aluminium, and copper is preferable. The water-soluble copper phthalocyanine dye includes C.I.direct blue86, C.I.direct blue87, C.I.direct blue199, C.I.acid blue249, C.I.reactive blue7, C.I.reactive blue15, C.I.reactive blue21 and C.I.reactive blue71.

**[0026]** The water-based cyan ink composition containing the water-soluble metal phthalocyanine dye is produced, for example, by a method similar to that of the above water-based magenta ink composition and injected in a container, which is set at the prescribed position of an ink-jet printer to use in the same way as the container of the above water-based magenta ink composition.

**[0027]** The water-based ink composition of the present invention can give an ideal magenta color which has vividness, color tone indicated in the above "Japan Color Standard Paper", high tinge and moderate blueness, and therefore, can be used together with a yellow or cyan ink to give a wide visible range of color tone. Further, the composition can be used together with existing yellow, cyan and black excellent in light fastness and water fastness to give a recorded product excellent in light fastness and water fastness.

## EXAMPLE

[0028] The present invention will be described below in more details with reference to Synthesis Example and Example. "part" and "%" in the description are shown by weight unless otherwise specified.

### Synthesis Example 1

[0029] 63.7 parts of 96 % sulfuric acid was charged in a reactor, followed by addition of 65.9 parts of 32.7 % fuming sulfuric acid thereto under cooling on ice, to prepare 7.9 % fuming sulfuric acid. 20.4 parts of the Compound of Formula(2) was added thereto below 20 °C under cooling on ice, sulfonated at a temperature of 20 to 25 °C for 3 hours, and then added to 300 parts of icy water, followed by addition of 20 parts of sodium chloride under stirring. The solution was stirred for 1hr, filtered and then washed with 30 parts of 10% aqueous sodium chloride solution to obtain a wet cake. The wet cake was stirred with 300 parts of water for 30min, and filtered to remove a small amount of insoluble matter. To the filtrate 25 parts of sodium chloride was added under stirring for salting out, followed by stirring for 1hr. The resultant product was filtered and dried to obtain a reddish powder of the dye component to be used in the present invention.

[0030] Alternatively, the wet cake was stirred at the room temperature for 1hr in methanol 2.3 times as much as the wet cake by weight, filtered, washed with methanol and dried to obtain 24.3 parts of a clearly red crystal of the dye ( $\lambda_{\text{max}}$ : 529nm(in water)) containing the compound of Formula (1) and having the least amount of inorganic salt.

[0031] The product contained the disulfonic acid compound represented by Formula (1) by 95% or more, monosulfonic acid compound by 1% or less and a total of sodium chloride and sodium sulfate by 1% or less according to the HPLC area ratio.

### Example 1

#### (1) Preparation of the ink composition

[0032] The water-base ink composition for ink-jet printing was produced by preparing a liquid of the composition as described in Table 1 below and filtering through a 0.45 $\mu$ m membrane filter (by Toyo Roshi KK). The composition deposited no crystal even after 6 months of the production and so had good storage stability.

Table 1  
(Composition)

Dye containing the compound of Formula(1)(note)	4.5 parts
Water	75.5 parts
N-methylpyrrolidine-2-one	5.0 parts
Ethylene glycol	5.0 parts
Glycerin	5.0 parts
Urea	5.0 parts
Total	100.0 parts

(note) the monosulfonic acid compound content of 0.5% or less (measured by HPLC in the above condition); the total content of sodium chloride and sodium sulfate of 1% by weight or less; solubility in pure water(ion exchanged water) of about 100g/L (25°C)

#### (2) Ink-jet recording

[0033] By using an inkjet-printer (Trade name: NOVAJET III, by ENCAD CO.), ink-jet recording was done on an available coated sheet (Coated paper STX73A4 for color image jet; by Sharp, Co.).

#### (3) Hue and vividness of recorded image

[0034] A recorded paper was applied to COMSEK-V colorimetric system (by Nippon Kayaku KK) to calculate  $L^*$ ,  $a^*$ ,  $b^*$

values. Hue was evaluated by comparison with color samples of standard magenta of the "Japan Color Standard Paper" published by Japan Printing Machinery Manufacturers Association (JNC), and vividness was evaluated by the formula:

$$C^* = ((a^*)^2 + (b^*)^2)^{1/2}$$

#### (4) Light fastness test of recorded image

**[0035]** A carbon arc fade meter ( by Suga Testing Machine Co.) was used to irradiate carbon arc on the recorded papers for 20 hours. Change between before and after the irradiation treatment was determined according to JIS blue scale, and color difference between before and after the irradiation treatment was measured by the above colorimetric system.

#### (5) Water fastness test of recorded image

**[0036]** A recorded paper was immersed in a beaker of water, stirred for 2 minutes, picked out, and air-dried. Change between before and after the immersion treatment was determined according to JIS brown gray scale, and color difference between before and after the immersion treatment was measured by the above colorimetric system.

**[0037]** Test results in hue, vividness, light fastness, and water fastness of recorded images printed by the water-based magenta ink composition prepared in Example 1 are shown in Table 2.

Table 2

	Hue			Vividness	Light fastness	Water fastness
	L*	a*	b*	c*	Judgment (ΔE)	Judgment (ΔE)
JNC Standard Magenta	46.3	74.4	-4.4	74.5		
Ink composition of Example 1	47.7	73.1	-11.4	74.0	Grade 4 (8.3)	Grade 4 (10.2)

**[0038]** Table 2 reveals that the ink composition of Example 1 is excellent because the magenta is close to the standard magenta in hue and vividness and the differences in color is little between before and after the respective test of light fastness and water fastness. Further, the dye component used in the Example, which has a solubility in water of 100g/L, is excellent for ink-jet recording and can produce a high concentration of ink composition.

#### Example 2

##### (1) Preparation of ink composition

**[0039]** A magenta ink composition was produced by the same way as described in Example 1 except that 3.8 parts of the dye containing the compound of Formula (1) and 76.2 parts of water were used. For Comparative Example 1, a magenta ink composition was produced by using the dye(M-2:C.I.(Color Index) Acid Red 82)as described in JP Laid Open No.195775/1982 and adjusting its optical density to be equal to the above ink composition.

##### (2) Ink-jet printing

**[0040]** In order to determine the range of blend color, the above (1) ink composition for a magenta ink composition, the yellow ink and the cyan ink attached to a printer were used to print in unicolor and blend color(red, blue), where the ink-jet printer(Trade name: BJF-600, by Canon KK) and the available coated sheet(Coated paper STX73A4 for color image jet; by Sharp, Co.) were used.

##### (3) Determination of color

**[0041]**  $a^*$ ,  $b^*$ , and  $C^*$  were calculated according to the way as described in Example 1(3). The results are shown in Table 3 and Fig. 1.

Table 3

	red	magenta	blue	yellow	cyan	green
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		red	magenta	blue	yellow	cyan	green
a*	Exam.2	69.6	74.1	19.5	-1.4	-28.9	-47.8
	Comp.1	63.8	71.1	11.2			
b*	Exam.2	44.3	-5.6	-52.5	78.6	-38.9	38.6
	Comp.1	52.9	11.3	-48.6			
C*	Exam.2		74.3				
	Comp.1		72.0				
( Exam.2: Example 2; Comp.1: Comparative Example 1)							

**[0042]** Table 3 reveals that the magenta used in the present invention is -5.6 in b\* which is shifted by 16.9 toward the minus direction from that of the magenta of Comparative Example 1, so that the former is an ideal magenta color having a moderate blueness. The blue obtained by mixing the cyan also is -52.5 in b\*, so that it has a more strong blueness. It is found by plotting a\* and b\* values of Table 3 on a chromaticity diagram that the magenta of the present invention has a wider range than that of Comparative Example 1 in the field of + a\* and - b\*, which means said magenta can exert more hue by a blend color in this field. Furthermore, the magenta used in the present invention has a higher value of C\*, the indicator of vividness, which means it has a higher vividness. These results show that a higher vividness, a wider range of blend color and, particularly, a more excellent B(blue) and M(magenta) can be obtained when the ink composition of Example 2 is used. The same tests of light fastness and water fastness conducted on the sample of Comparative Example 1 as on the sample of Example 1 reveal that it is of grade 4 in light fastness but is grade 3 in water fastness so that it is inferior in water fastness to the magenta used in the present invention.

#### Example 3

##### (1) Preparation of ink composition

**[0043]** A magenta ink composition was produced by preparing and filtering in the same way as described in Example 1 except the case in which the magenta dyes as described below were used.

##### Magenta dye

##### **[0044]**

- M1: the magenta dye used in the present invention  
M2: the available ink (containing an azo type dye) for as ink-jet printer

##### Cyan dye

##### **[0045]**

- C1: C.I.direct blue 86(cupric phthalocyanine type dye)  
C2: C.I.direct blue 199(cupric phthalocyanine type dye)  
C3: C.I.reactive blue 71(cupric phthalocyanine type dye)

##### (2) ink-jet printing

**[0046]** The ink-jet record was conducted according to Example 1 by using the ink-jet printer ( Trade name: NOVAJET III, by ENCAD CO.)with a magenta ink alone or with a magenta ink and a cyan ink overlapped to an available plain paper(PB PAPER, by Canon KK) and the glossy paper(Color BJ photo sheet film(CA-101)by Canon KK)having the dye-acceptable layer on them.

##### (3) Light fastness test of recorded image

**[0047]** The recording paper printed in (2) was subject to a 48hrs light fastness test using the acceleration type xenon light fastness tester made by WACOM.

#### (4) Determination of color

**[0048]** Hues of the recorded image before and after the light exposure were measured to calculate the color difference( $\Delta E$ ) using the colorimeter(GRETAG SPM59, by GRETAG Co.). The results are shown in Table 4.

Table 4

No.	General paper	Enameled paper	Remark
1-1	11.3	9.6	M1 alone
1-2	6.1	7	M1 and C1 overlapped
1-3	3.0	5.8	M1 and C2 overlapped
1-4	6.6	6.9	M1 and C3 overlapped
2-1	11.1	13.5	M2 alone
2-2	12.6	17.8	M2 and C1 overlapped
2-3	11.3	15.3	M1 and C2 overlapped
2-4	10.2	23.5	M1 and C3 overlapped

**[0049]** In Table 4, No.1-1 to No.1-4 are the present invention samples and No.2-1 to No.2-4 are the reference samples. In Comparison of No.1-1 with No.2-1 shows they are of the same level in color difference( $\Delta E$ ) between before and after the exposure on the plain paper. However, the reference sample shows a larger color difference due to the exposure on the glossy paper than on the plain paper; contrary to the above, the present invention sample shows a smaller color difference on the glossy paper than on the plain paper. These facts mean that both the present invention sample and the reference sample have the same level of light fastness on the plain paper, but that the reference sample has a lower and decreased light fastness on the glossy paper than on the plain paper while the present invention sample has a higher and increased light fastness.

**[0050]** The comparison in the results of the magenta dye alone with a combination of the magenta dye and the copper phthalocyanine type cyan dye is as follows. In the reference samples (in comparison of No.2-1 with No.2-2 to 2-4), the color differences in the combination case are almost none or slightly exceed that of the magenta alone on the plain paper, but they increasingly exceed on the glossy paper. On the other hand, in the present invention samples (in comparison of No.1-1 with No.1-2 to 1-4), the color differences in the combinations case are much smaller than that of the magenta alone on both the plain and glossy paper. These facts mean that, in a combination with metal phthalocyanine type cyan dye, the reference sample has the same or decreased light fastness while the present invention sample has an increased light fastness.

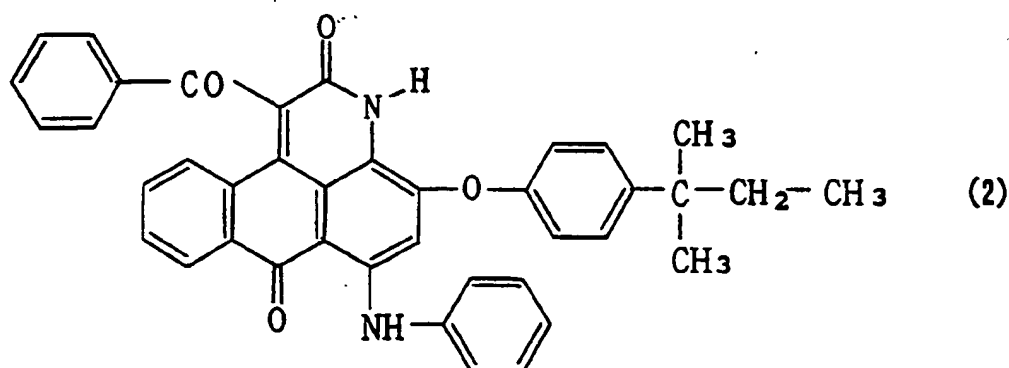
#### INDUSTRIAL APPLICABILITY

**[0051]** The anthrapyridone compound used in the present invention is excellent in solubility in water and is characterized as having a good ability to filter through a filter material, such as membrane filter. The anthrapyridone compound is highly safe for a humane body. Furthermore, the ink composition of the present invention using the anthrapyridone compound neither show a crystal deposition after a long storage nor a change in property (for example, an elapse change in viscosity or surface tension) and a color. It has good storage stability. The ink composition of the present invention, when used as a magenta ink for ink-jet recording, can give a printed matter excellent in light fastness and water fastness. Furthermore, the ink composition, when used together with a yellow, cyan or black dye, also enables ink-jet recording excellent in light fastness and water fastness. The ink composition displays the effect strikingly when applied to an information paper, especially to the one having an ink-acceptable layer. The ink composition, when used together with a metal phthalocyanine type cyan dye, can also increase a light fastness, and, additionally, provide a clear printed surface and an ideal magenta color. The ink composition, when used together with a yellow or cyan ink, can provide a wide visible ray range of color tone.

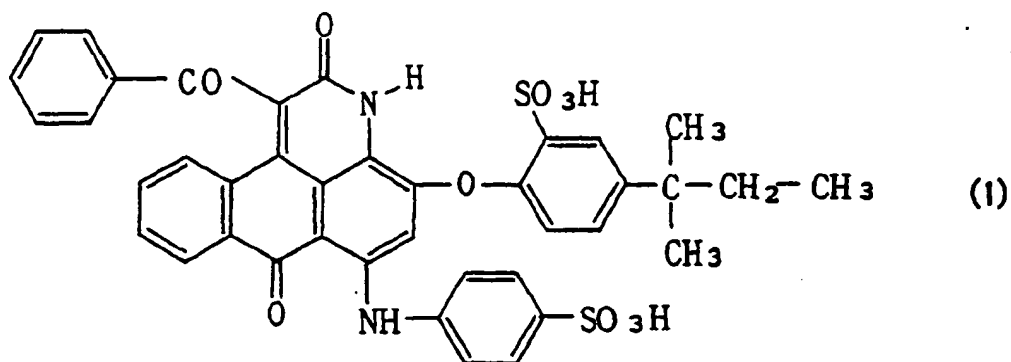
**[0052]** Therefore, the ink composition of the present invention is very useful as a magenta ink for ink-jet recording.

#### Claims

1. A water-based magenta ink composition, which comprises the disulfonic acid derivative of a compound represented by Formula(2) or the salt thereof as the dye component.



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2. A water-based magenta ink composition according to claim 1, wherein said disulfonic acid derivative of a compound represented by Formula(2) is 85% or more (area ratio according to HPLC)in content and a monosulfonic acid compound of the compound represented by Formula(2) according to claim (1) is 10% or less(area ratio according to HPLC)in content.
  3. A water-based magenta ink composition according to claim 1 or 2, wherein said disulfonic acid compound is a compound (or the salt thereof, hereinafter likewise)represented by Formula(1).



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4. A water-based magenta ink composition according to any of claim 1 to 3, wherein said composition contains water and an organic solvent.
  5. A water-based magenta ink composition according to any of claim 1 to 4, wherein an inorganic salt in said dye component is 1% or less in content.
  6. A water-based magenta ink composition according to any of claim 1 to 5, wherein said composition is for ink-jet recording.
  7. A method for ink-jet recording, which comprises using the water-based magenta ink composition according to any of claim 1 to 5 for an ink in the ink-jet recording way that ink droplets are jetted responding to recording signals to record on a recording material.
  8. A method for ink-jet recording, which comprises using the water-based magenta ink composition according to any of claim 1 to 5 for a magenta ink, and using a water-based cyan ink containing a water-soluble metal phthalocyanine dye for a cyan ink in the ink-jet recording way that ink droplets are jetted responding to recording signals to record on a recording material.
  9. A method for ink-jet recording according to claim 8, wherein said recording material is a polyamide fiber material,

which is thermally treated after jetting said ink composition.

10. A method for ink-jet recording according to claim 8, wherein said recording material is a sheet for information transmitting.
- 5 11. A method for ink-jet recording according to claim 10, wherein said sheet for information transmitting is a surface-treated sheet.
12. An Ink-jet printer equipped with a container storing the water-based magenta ink composition according to any of claim 1 to 5 and a container storing the water-based cyan ink containing a water-soluble metal phthalocyanine dye.
- 10 13. A dye for water-based magenta ink, which comprises containing the disulfonic acid compound represented by Formula(1) or the salt thereof by 90% or more(area ratio according to HPLC), the monosulfonated product ( monosulfonic acid compound) of the compound represented by Formula(2) by 5% or less(area ratio according to HPLC), and the inorganic salt by 1% or less.
- 15 14. A method for producing the disulfonic acid compound represented by Formula (1) or the salt thereof, which comprises disulfonating the anthrapyridone compound represented by formula (2) with fuming sulfuric acid, salting out conventionally the disulfonic acid compound thus obtained to give a wet cake, and then treating the wet cake with hydrous lower alcohol.

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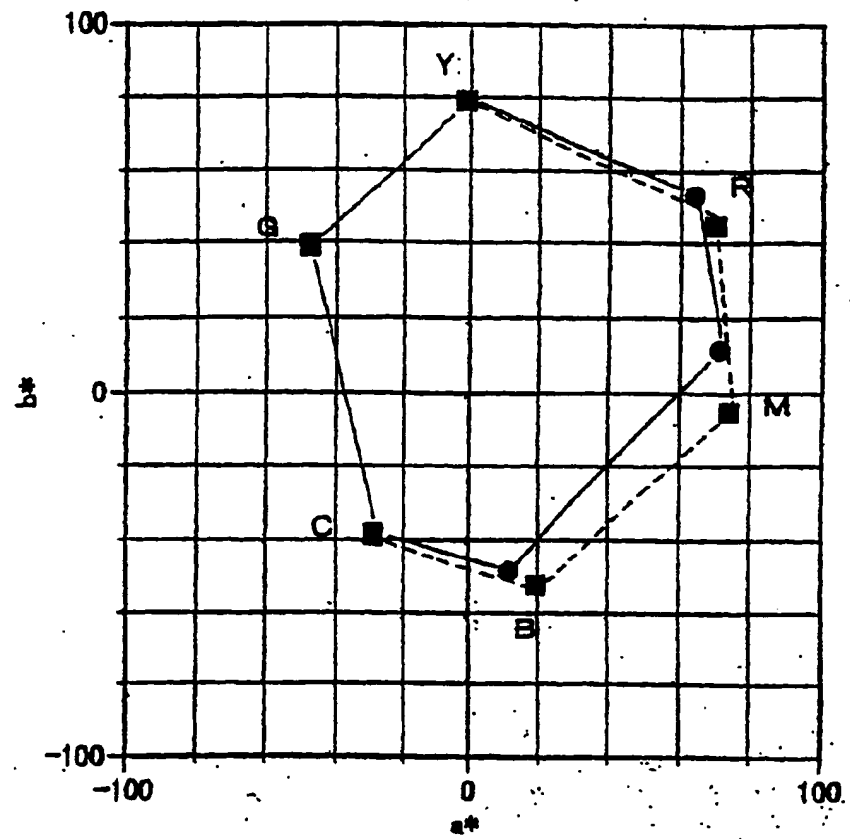
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Fig.1



■ : Example 2

● : Comparative Example 1



# INTERNATIONAL SEARCH REPORT

International application No.  
PCT/JP99/01050

<b>A. CLASSIFICATION OF SUBJECT MATTER</b> Int.Cl <sup>6</sup> C09D11/00, C09B5/14, B41J2/01		
According to International Patent Classification (IPC) or to both national classification and IPC		
<b>B. FIELDS SEARCHED</b> Minimum documentation searched (classification system followed by classification symbols) Int.Cl <sup>6</sup> C09D11/00, C09B5/14, B41J2/01		
Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched		
Electronic data base consulted during the international search (name of data base and, where practicable, search terms used) CA (STN), REGISTRY (STN)		
<b>C. DOCUMENTS CONSIDERED TO BE RELEVANT</b>		
Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X Y	US, 2644821, A (SANDOZ A.G.), 7 July, 1953 (07. 07. 53), EXAMPLE 1 (Family: none)	13, 14 1-12
Y	JP, 2-16171, A (Ricoh Co., Ltd.), 19 January, 1990 (19. 01. 90), Claims ; page 3 (Family: none)	1-12
<input type="checkbox"/> Further documents are listed in the continuation of Box C. <input type="checkbox"/> See patent family annex.		
* Special categories of cited documents: "A" document defining the general state of the art which is not considered to be of particular relevance "E" earlier document but published on or after the international filing date "L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified) "O" document referring to an oral disclosure, use, exhibition or other means "P" document published prior to the international filing date but later than the priority date claimed "T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention "X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone "Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art "&" document member of the same patent family		
Date of the actual completion of the international search 25 May, 1999 (25. 05. 99)		Date of mailing of the international search report 8 June, 1999 (08. 06. 99)
Name and mailing address of the ISA/ Japanese Patent Office		Authorized officer
Facsimile No.		Telephone No.

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